

Work Order ID 82667

82667

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April-04-12 1:53:57 PM

Item ID: D2713 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 04/04/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 18/04/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2713 | Rev A | | | | | | | | |
| 100 | BAND SAW | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Bandsaw | Memo | 0.00 | | | | | | | |
| Jeaspa Bandsaw | Cut D2761 extrusion to 3.100" +0.015/-0.000 | | | | | | | | |
| | | | B.A | 12/10/20 | | 10 | φ | | |
| 110 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | Machine per folio H2713 and drawing D2713Deburr & Tumble. | | | | | | | | |
| | | | B.A | 12/10/20 | | 10 | φ | | |
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | B.A | 12/10/20 | | 10 | φ | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82667

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Item ID: D2713

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug

Stop ***NS2***

Start Date: 04/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

Memo

START TIME:


FINISH TIME:

OVEN TEMPERATURE:

m122878

3200F

3715

10X  12/10/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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April-04-12 1:53:57 PM

Item ID: D2713

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 04/04/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 21479

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

10

16

12/10/23 JS

12/10/24

12-10-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-04-12 1:54:00 PM

Page 1

Work Order ID: 82667

82667

Parent Item: D2713

D2713

Parent Item Name: Lug

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C02.01.14Added Tumble at step 5NG/EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2761-108 | | Manufactured | No | | | 100 | f | 1,148.696 | 0.2916 | 3.069474 | | | |

D2761-108

Extrusion (HPK)

**

S.A 12/10/20

Location

Loc Qty

Loc Code

MAT007

1148.69644

→ 80206

1138.4

8323

10.29644

2.6375 ft

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

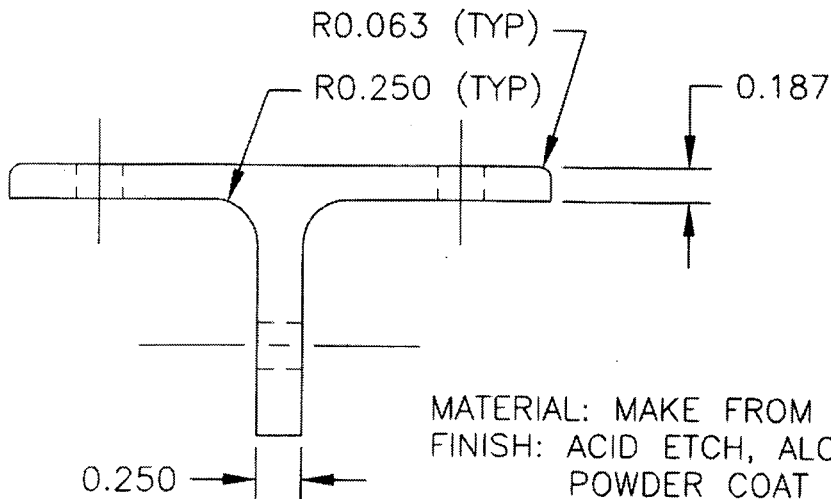
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



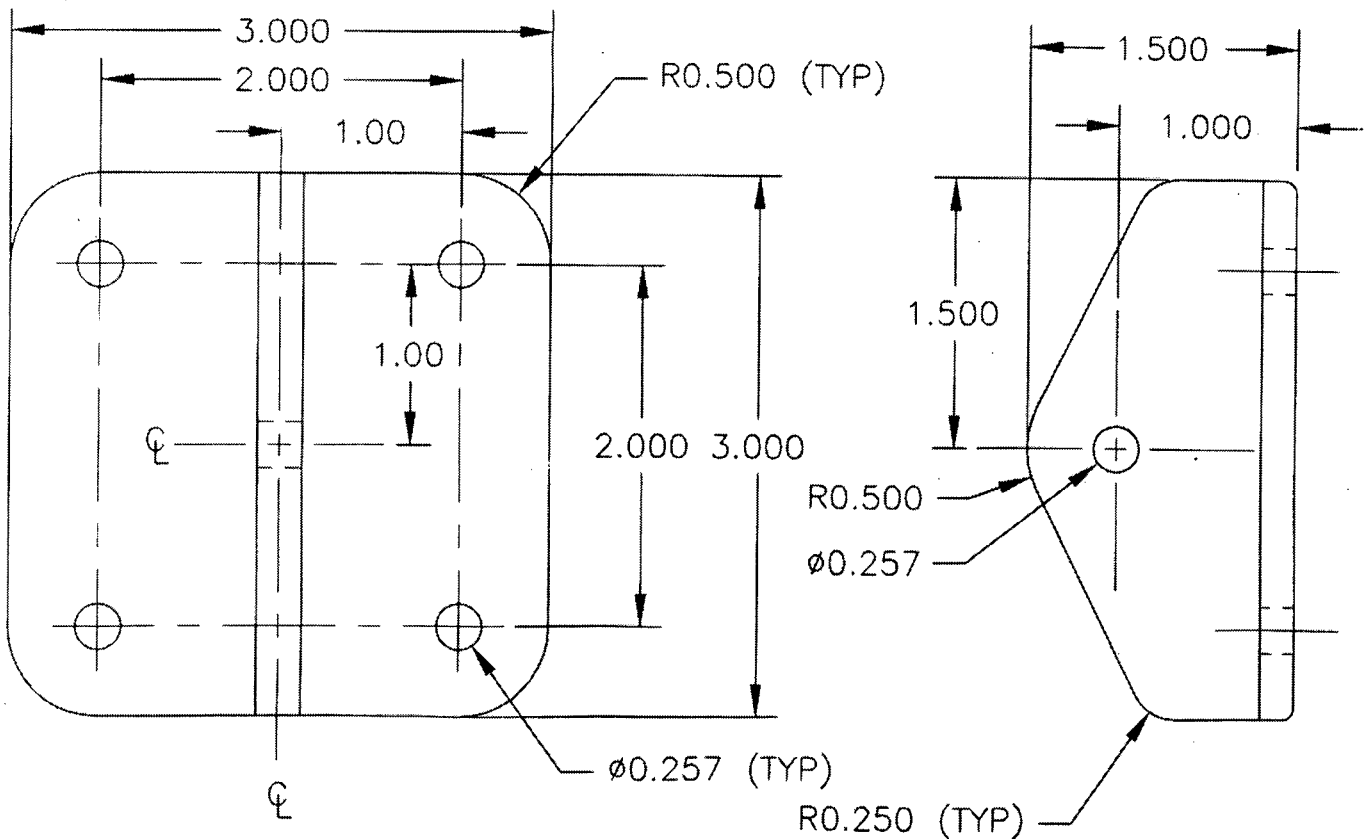
| | | | |
|------------------------|-----------------------|---|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>D.M.</i> | APPROVED <i>SA</i> | DRAWING NO. D2713 | REV. A SHEET 1 OF 1 |
| DATE 98.04.01 | | TITLE BRACKET | SCALE 1:1 |
| A | 98.04.01 | NEW ISSUE | |



RELEASED
98/04/20 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82667
12/04/04

MATERIAL: MAKE FROM EXTRUSION D2761
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|--|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 82667 |
| Description: BRACKET | | Part Number: D2713 |
| Inspection Dwg: D2713 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| R0.063 | +/- .010 | R0.063 | ✓ | | R-6 | ref. |
| R0.250 | +/- .010 | R0.250 | ✓ | | " | " |
| 0.187 | +/- .010 | 0.185 | ✓ | | Vern | 6A-01 |
| 0.250 | +/- .010 | 0.244 | ✓ | | " | " |
| 3.000 | +/- .010 | 2.996 | ✓ | | " | " |
| 2.000 | +/- .010 | 2.000 | ✓ | | " | " |
| 1.00 | +/- .030 | 1.007 | ✓ | | H-6 | 31006 |
| R0.500 | +/- .010 | R0.500 | ✓ | | R-6 | ref. |
| 1.00 | +/- .030 | 1.000 | ✓ | | H-6 | 31006 |
| 2.000 | +/- .010 | 2.000 | ✓ | | Vern | 6A-01 |
| 3.000 | +/- .010 | 3.002 | ✓ | | " | " |
| φ0.257 | + .006 / - .001 | φ.257 | ✓ | | " | " |
| R0.500 | +/- .010 | R0.500 | ✓ | | R-6 | ref. |
| φ0.257 | + .006 / - .001 | φ0.258 | ✓ | | Vern | 6A-01 |
| 1.500 | +/- .010 | 1.501 | ✓ | | H-6 | 31006 |
| 1.000 | +/- .010 | 1.001 | ✓ | | " | " |
| 1.500 | +/- .010 | 1.505 | ✓ | | " | " |
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|-------------------------|-----------------------|------------------------------|
| Measured by: L.A | Audited by: RP | Preliminary Approval: |
| Date: 12/10/20 | Date: 2-10-20 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15